

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

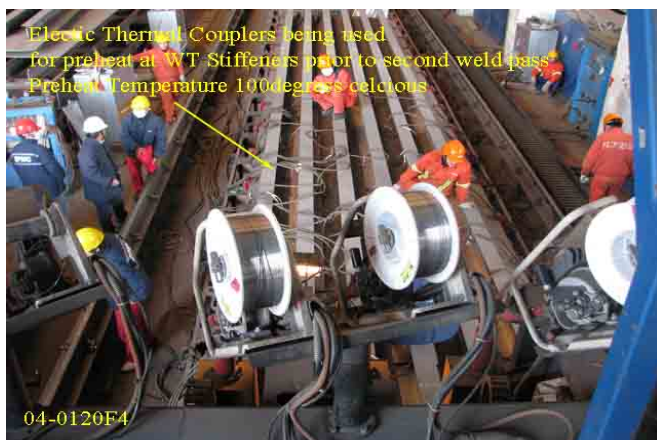
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001625**Date Inspected:** 13-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Wu Ming kai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** WT Stiffeners**Summary of Items Observed:**

This Quality Assurance (QA) Inspector arrived at ZPMC for observation of the Orthotropic Bridge Deck components being fabricated in bay 3. Upon observation of the T stiffeners ZPMC personnel were observed using electric thermal couplers for the pre-heat requirement according to Welding Procedure Specification number WPS-B-T2132-3 required 100° Celsius for fracture critical members greater than 20mm in thickness. The thickness of the material came into question with ZPMC Quality Control (QC) personnel Wu Ming Kai This QA inspector along with Wu Ming Kai verified the thickness and was determined that 100° c was the correct preheat for this component. At this time ZPMC re-attached the electric thermal couplers and increase the pre-heat to the appropriate temperature.



WELDING INSPECTION REPORT

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Summary of Conversations:

This QA inspector spoke with ZPMC QC inspector Wu Ming Kai in regards to the proper pre-heat requirements. The QC inspector stated that 60°C was required but further conversation with him and verification. The QC inspector returned and stated that the material was 22mm in thickness and 100°C was required.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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| Inspected By: | Riley, Ken | Quality Assurance Inspector |
| Reviewed By: | Cochran, Jim | QA Reviewer |
